Work Orde Thursday, April													Page 1
Item ID: Revision ID: Item Name:	D3255-041 Access Panel A	Assembly			Accept					Setup	Start Stop		
	4/20/2011	Start Qty: 200 Req'd Qty: 400	we			Cust Item I Customer:	D:			·		1 18811181 8	
Approvals:	Process Pla	ın:	Date:_	1-09-21	Tooling: SPC (Y/N):		nte:			Run	Start Stop		
Sequence ID/ Work Center II)	Operation Description			Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	t Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr											
D3255	Rev	В											
100 Large Fab Large Fab		Large Fab Memo 1-Weld a Batch:	s per Dwg D32 M/15778	55 ***purge v □2-Grind	0.00 0.00 veld***□A/R SS R Welds Flush	COD		A	11.5	P6.5	7	<u></u>	
QC Quality Control		QC10- Inspect visual Memo	per QS1004- gr	ound welds	0.00 5 ,	راه (دی							
120 QC		QC5- Inspect part cor	mpleteness to st	ep on W/O	0.00	ساملولىد			(+2				

Quality Control

W/O:			W	ORK ORDER C	ANGES					*
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Car	tegory:	NC	CR: Yes	No DQ	A :	Date:	
	R	esolution:	Disposit	ion:	Q/	A: N/C CI	osed:		Date: _	
NCR:			WORK ORI	DER NON-CONF		E (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descri	Section B ption	Sign &	Verific Secti		Approval Chief Eng	Approval QC Inspector
			Cilier Eng	Office Eng		Date				
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Work Orde Thursday, April							Page 2
Item ID: Revision ID: Item Name:	D3255-041 Access Panel A	Accembly		Accept		Setup Start	
Start Date: Required Date: Reference:	4/20/2011	Start Qty: 4.00 Req'd Qty: 4.00	1 18 18 18 18 18 18 18 18 18 18 18 18 18		Cust Item ID: Customer:		
Approvals:		n:	Date:	Tooling: SPC (Y/N):	Date:	Run Start Stop	
Sequence ID/ Work Center II 130 Powdercoat Powder Coating 140 QC Quality Control	, 28	Operation Description Grey Sandtex(Ref.4.3.5.6 Memo START TIM 2223 QC3- Inspect Part Finish Memo	67	Set Up/ Run Hour 0.00 30 0.00 OVEN TEMPER 0.00 0.00		de Qty Qty	Reject Insp. Number Stamp M-1-06/08
150 Small Fab Small Fab		D3255 □ A/R	55-5 gasaket to d3255-04 2 736 DOW COI	0.00 0.00 41 using Dow corning RNING ADHESIVE	Sb Ulo6/09 adhesive as per Dwg	2	

Dart Aerospace Ltd

W/O:			W	ORK ORDER CH	ANGES					· ·
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		Description of NC		Corrective Action	Section B		Verifi	cation	Approval	Approval
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Work Order ID 68780

QC

Quality Control



Page 3

Thursday, April 21, 2011 8:49:27 AM D3255-041 Item 1D: Accept Setup Start **Revision ID:** Stop Access Panel Assembly Item Name: **Start Date:** 4/20/2011 Start Qty: 4.00 **Cust Item ID:** Required Date: 4/25/2011 Req'd Qty: 4.00 **Customer:** Reference: Run Start Process Plan: Tooling: Approvals: Date: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 160 QC5- Inspect part completeness to step on W/O wools QC 0.00 Memo **Quality Control** Identify as per dwg & Stock Location: 170 0.00 PPP 69192 Packaging 0.00 Memo 11 6/13 D MF 11-06-10 Packaging 180 QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

W/O:			W	ORK ORDER CH	IANGES					. •
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Picklist Print

Thursday, April 21, 2011 8:49:34 AM

Work Order ID: 68780

D3255-041

Parent Item Name: Access Panel Assembly

Parent Item:



Start Date: 4/20/2011

Required Date: 4/25/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:	IPP Rev:C	Removed Manufacturing of D3255-1/-2/-3	06-08-02	JLN

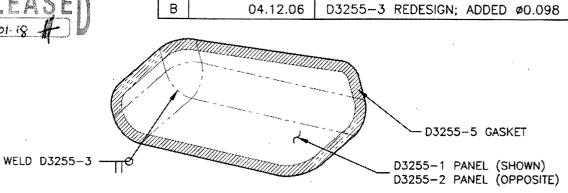
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-1		Manufactured	No		,	100 B6878D	Each	0.0000	1 	RD)	M //	,06.0	08
D3255-5 Gasket		Manufactured	No			100	Each	2.0000	1 	4 	W	6/08	
				<u>Location</u> GA	66574	Loc Q	ty 2 2 6 2	763	(2	_	·	
D3255-3		Manufactured	No			150	Each	17.0000	1	OH	11.0	26, <i>0</i> 8	
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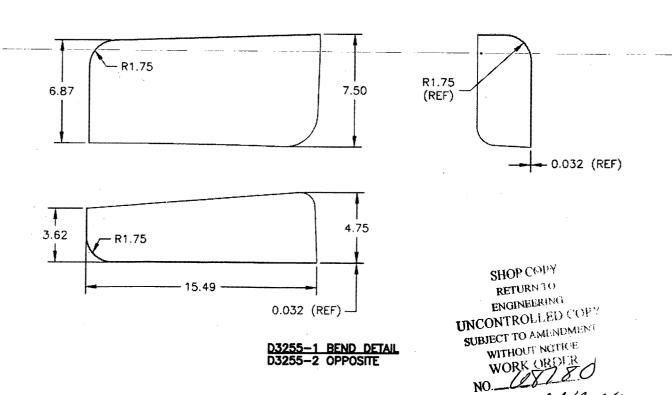


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04.1	2.06		ACCESS PANEL ASSEMBLY		1	1:6
Α		04.01.27	NEW ISSUE			



D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)

M11-04-21



D3255-041/-042 NOTES: 1) WELD PER DART QSI 004

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS

4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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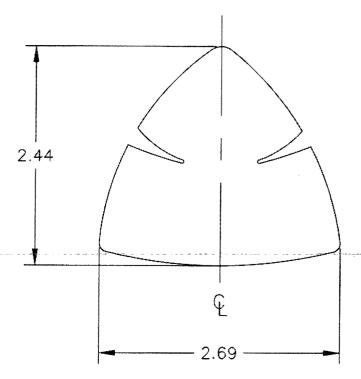
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D3255-3 CAP FORM TO FIT D3155-1/-2 uli as 280

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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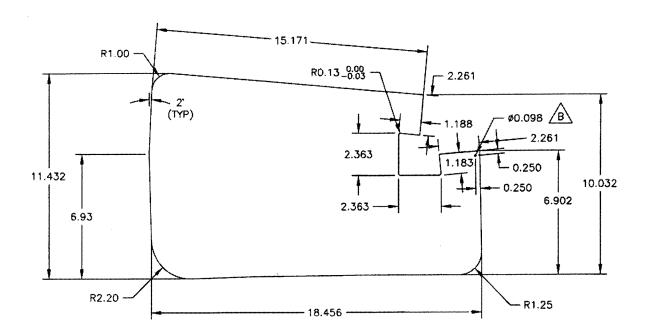
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NOTE: Date & initial all entries



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04.12.06		ACCESS PANEL ASSEMBLY	1:5





ulo 68788

D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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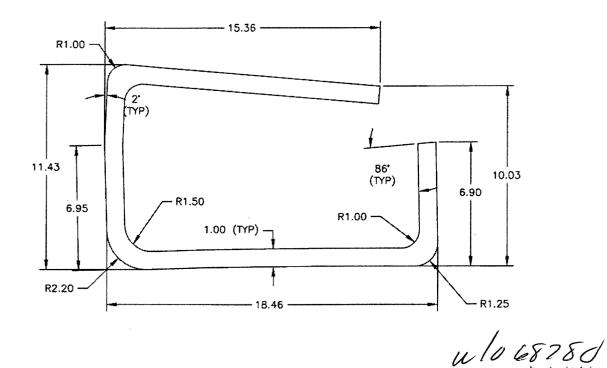
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D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16
 - POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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